



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3171-3
Job Sheet 167883



Part No: D3171-3

Part Name: Angle



Part Weight: 0 lbs

Job Created: 11/7/17

Due Date: 11/10/17

Type: SOLD

Ship Via:

Job Qty: 10 ea

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		11/9/17	0.00	0.00	Start Up Waterjet1		
100	Waterjet	10 pcs		11/9/17	0.00	1.55	Waterjet1		DL
120	QC	10 pcs		11/9/17	0.00	0.00	QC8		DL DAS 38
130	Brake NC	10 pcs		11/10/17	0.02	0.08	Brake NC 1		ES DAS 38
150	QC	10 pcs		11/10/17	0.00	0.00	QC5		ES 38
160	Packaging	10 pcs		11/10/17	0.00	0.00	Packaging3	5+0.19	10/11/17 14:20 DAS
170	QC21-SA	10 Ea		11/10/17	0.00	0.00	QC21		0 7-89

Part Op 100 - 1-Cut as per Dwg D3171
Descriptions: 130 - Bend as per Dwg D3171

DAS
21
9-89

NOV 15 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S24GA	0	73	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Angle	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
2	Angle	0.500Inches + 0.006 - 0.001	0.506 0.499	Diameter	
3	Angle	0.400Inches ± 0.030	0.430 0.370		
4	Angle	0.590Inches ± 0.010	0.600 0.580		
5	Angle	1.180Inches ± 0.030	1.210 1.150		
6	Angle	2.580Inches ± 0.030	2.610 2.550		
7	Angle	0.025Inches ± 0.010	0.035 0.015		
8	Angle	1.587Inches ± 0.010	1.597 1.577		

DART
AEROSPACE
S009213

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CANADA
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Email: sales@dartaero.com
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Angle

PART NO: D3171-3

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 11/13/17

Job No: 167883

167883

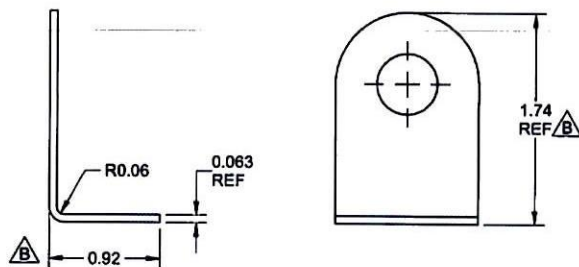
INSPECTION SHEET

[illegible]

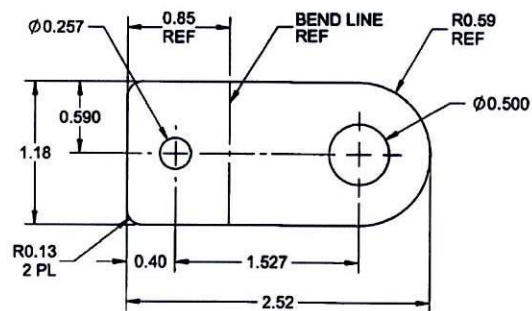
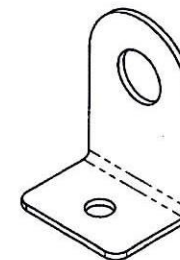
Measured by:	<i>de</i>	Checked by:	<i>38</i>	QC Inspector:	
Date:	<i>17/11/10</i>	Date:	<i>NOV 13 2017</i>	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	



D3171-1 ANGLE
(MAKE FROM D3171-1F)



D3171-1F
FLAT PATTERN

D3171-1/1F NOTES:

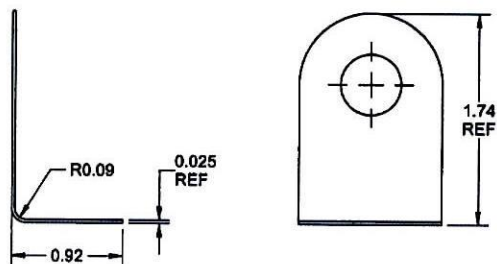
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, ANNEALED, 0.063 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

167883

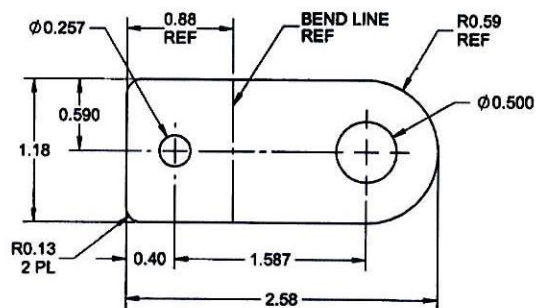
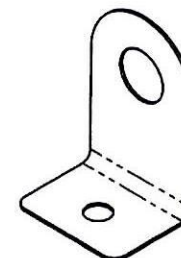
RELEASED
2016-11-09
82116-668

APPROVED

B	UPDATE TO CURRENT STANDARD; D3171-1: 0.92 AND 1.74 REF WERE 0.90 REF AND 1.72 (MFG REQUEST/CAD ERROR); ADD D3171-3. REASON: PART-380.	MB	16.07.14
A	NEW ISSUE	DS	02.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	DD	D3171	SHEET 1 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	ANGLE	NTS
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D3171-3 ANGLE
(MAKE FROM D3171-3F)



D3171-3F
FLAT PATTERN

D3171-3/3F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, ANNEALED, 0.025 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S24GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

RELEASED
2016-11-09

APPROVED

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	DD	D3171	SHEET 2 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	ANGLE	NTS
DATE	16.07.14	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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